QUALITY VERIFICATION INSPECTION OF BALL AND ROLLER BEARINGS

REPORT NUMBER	DATE	CONTRACT NUMBER	NATIONAL STOCK NUMBER	CUSTOMER NAME/JOB ORDER

BEARING MANUFACTURER AND PART NUMBER	EQUIPMENT MANUFACTURER AND PART NUMBER

VISUAL INSPECTION

RING MARKINGS; *VENDOR CODE* _____ *VENDOR P/N* _____

VENDOR S/N _____ *OEM P/N* _____

VISUAL DEFECTS INSPECTED TO _____

NON-DESTRUCTIVE TESTING

HARDNESS; *INNER RING* _____ *OUTER RING* _____ *ROLLERS* _____

MAGNETIC PARTICLE; *INNER RING* _____ *OUTER RING* _____

FLUORESCENT PENETRANT; *CAGE* _____

GENERAL DIMENSIONAL INSPECTION

RINGS

INNER DIAMETER _____ OUTER DIAMETER _____

INNER RING WIDTH _____ OUTER RING WIDTH _____

RACEWAY DIAMETER; *INNER RING* _____ *OUTER RING* _____

LAND DIAMETER; *INNER RING* _____ *OUTER RING* _____

CORNER RADIUS; *INNER RING* _____ *OUTER RING* _____

RACE CURVATURE _____ CROSS CORNER WIDTH _____

LEAD-IN CHAMFER _____ LENGTH _____

RACEWAY RELIEF; *INNER* _____ *OUTER* _____

ELLIPTICITY _____ *MOUNTING SLOTS* _____

FLANGE DIAMETER _____ FLANGE WIDTH _____

RACEWAY CONCENTRICITY; *INNER* _____ *OUTER* _____

BALLS/ROLLERS

DIAMETER _____ GRADE _____ QUANTITY _____

RADIUS; *CROWN* _____ *CORNER* _____

LENGTH; *OVERALL* _____ *FLAT* _____

END FACE RUNOUT _____ ROLLER DROP _____

CORNER RADIUS RUNOUT _____ CROWN DROP _____

CAGE

DIAMETER; *BORE* _____ *OD* _____

WIDTH _____ WIDTH VARIATION _____

CLEARANCE; *TO FACE* _____ *TO LAND* _____

POCKET CLEARANCE; *CIRCUM* _____ *AXIAL* _____

CONCENTRICITY BORE-TO-OD _____

PLATING; *TYPE* _____ *THICKNESS* _____

SPECIAL DIMENSIONAL INSPECTION

ABEC/REEC REQUIREMENTS

PRECISION _____ INSPECT QUANTITY _____

RADIAL RUNOUT; *INNER RING* _____ *OUTER RING* _____

SIDE RUNOUT; *BORE* _____ *OD* _____

GROOVE RUNOUT; *REF SIDE* _____

WIDTH VARIATION; *INNER RING* _____ *OUTER RING* _____

GENERAL MEASUREMENTS

CLEARANCE; *RADIAL* _____ *AXIAL* _____

CONTACT ANGLE _____

FLUSHNESS _____ STICK OUT/IN _____

SURFACE FINISH; *BORE* _____ *OD* _____ *FACE* _____

LAND _____ *OR RACEWAY* _____ *IR RACEWAY* _____

BALL _____ *ROLLER* _____

CLEARANCE; *ROLLER END-TO-RING RIB* _____

SPECIAL INSTRUCTIONS

DESTRUCTIVE INSPECTION

QUANTITY _____ LAB ANALYSIS _____

MATERIAL ID; *RINGS* _____ *BALLS/ROLLERS* _____

CAGE _____

MICROSTRUCTURE _____ HEAT TREATMENT _____

MATERIALS ENGINEERING LAB REPORT NUMBER _____

LUBRICATION/PRESERVATION

LUBE; *TYPE* _____ *QUANTITY* _____

PRES; *TYPE* _____

SYMBOLS

* = 100% INSPECTION REQUIREMENT

** = DISASSEMBLE _____ EACH BEARING(S) AND PERFORM 100% INSPECTION AS NOTED.

REMARKS:

INSPECTION REQUIREMENTS PREPARED BY:	DATE:
BEARINGS TESTED BY:	DATE:
QUALITY VERIFICATION	DATE:

QUALITY INSPECTED	QUALITY CONFORMING	QUALITY NOT CONFORMING

LIST REJECTION CRITERIA ON BEARING INSPECTION REPORT FORM